



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW1205G00231-3G-PO

Job Sheet 185392



Part No: RBW1205G00231-3G-PO **Job Qty:** 3 ea

Part Name: Main Rotor Damper Oil Filling Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW1205G00231-3G Rev.2B IPP Rev. A 18.10.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		12/17/18	0.00	0.00	Purchasing		JAN 18 2019
110	Packaging	3 pcs		12/17/18	0.00	0.00	Packaging2		JAN 18 2019
120	QC	3 pcs		12/17/18	0.00	0.00	QC6		38
130	Packaging	3 pcs		12/17/18	0.00	0.00	Packaging3		Dart
140	QC21-FG	3 Ea		12/17/18	0.00	0.00	QC21		JAN 21 2019

Part Op 100 - Issue P/O: 041367 MANUFACTURE RBW1205G00231-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Rh

GA102

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW1205G00231-3Gp	Main Rotor Damper Oil Filling Adapter	3 pcs (1 ea)	100-Purchasing	S145954

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW1205G00231-3Gp	3	0	0

Part Specifications

Specifications could not be found.



Container No: S145956



Part: RBW1205G00231-3G

Job No: 185392

Serial No/Batch: S145956

Revision: 2B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

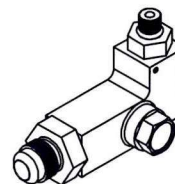
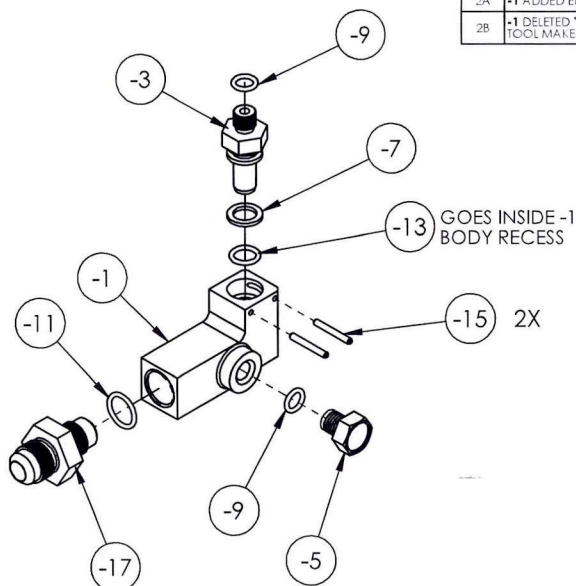
Date: 01/18/19

Plex 10/25/18 1:49 PM dart.Lussier.Patrick

9827
3613

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED PART -17, -1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG	
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG	
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE
2B	-1 DELETED $\nabla \phi .37 \times 90^\circ$, NEAR SIDE CALLOUT FROM 5/16-24 $\nabla .50$ BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE



FUNCTION: PART OF HELICOPTER SERVICING KIT T/N 3G1205G00131.
USED IN CONJUNCTION WITH A MANUAL HYDRAULIC OIL PUMP TO
RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER

ORIGINAL No. REF
RBW1205G00231-3G = 3G1205G00231
RBW1205G00213-3G-1 = 3G1205G00651
RBW1205G00231-3G-3 = 3G1205G00551
DO NOT USE, FOR REGERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	1-1/8 X 1-3/8 X 2-3/16	2
			-3	1	TUBE	6061	Ø3/4 X 1-1/2	3
			-5	1	AN PRESSURE RELIEF PLUG	ALUMINUM	AIRCRAFT SPRUCE #AN814-2D (MODIFIED)	4
			-7	1	WASHER	NYLON	Ø1/2 X 3/16	5
		B/O	-9	2	O-RING	VITON	ID 1/4 X 1/16 WMDTH #V75-010	1
		B/O	-11	1	O-RING	VITON	ID 7/16 X 1/16 WMDTH #V75-013	1
		B/O	-13	1	O-RING	VITON	ID 5/16 X 1/16 WMDTH #V75-011	1
		B/O	-15	2	ROLL PIN	STEEL	Ø2mm X 18mm McMaster-Carr #91611A108	1
		B/O	-17	1	FITTING	ALUMINUM	MS24392D6	1

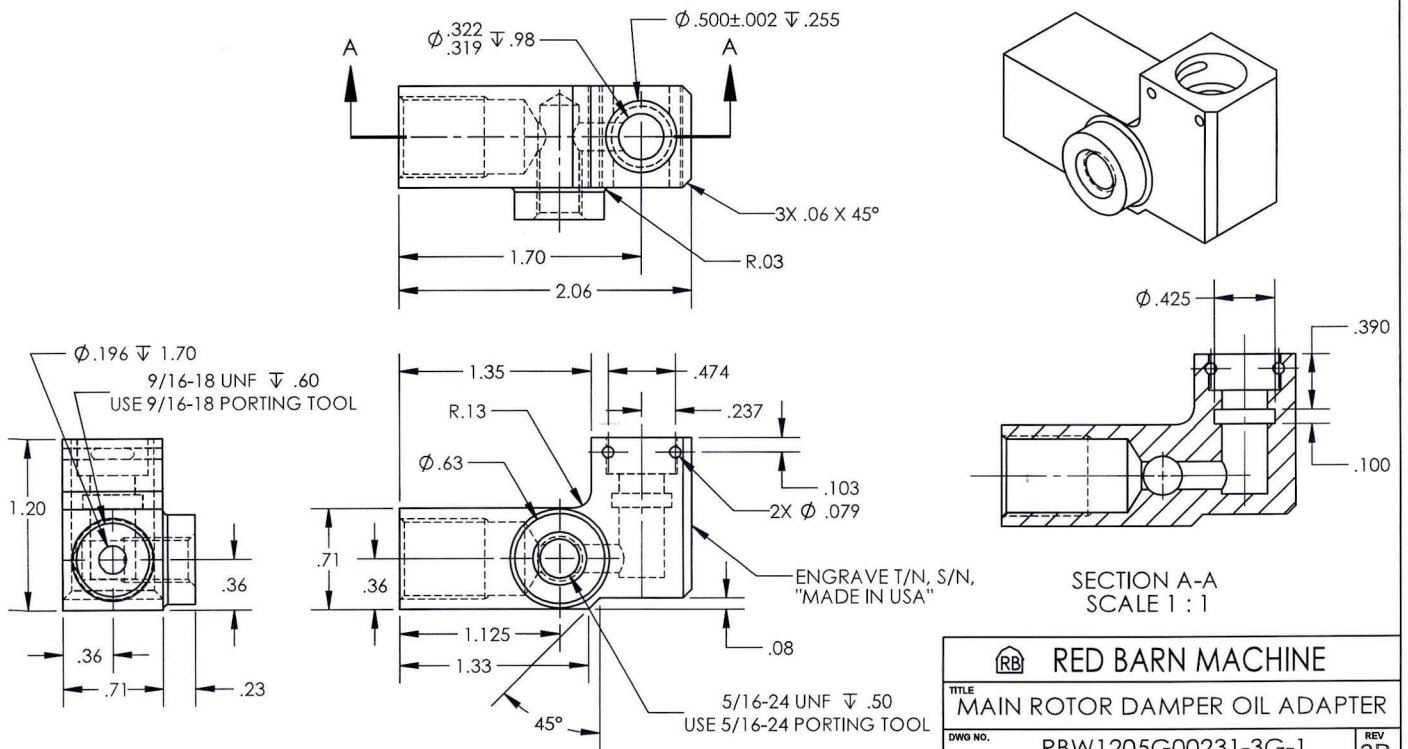


RED BARN MACHINE

TITLE	
MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO.	REV
RBW1205G00231-3G	2B
MAT'L	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± 5° SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:2	DATE 2/23/2011
SHEET 1 OF 5	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG	
2	-1 CHD TO USE PORTING TOOL 2 PLACES.	1/2/2011	JAG	
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/26/2012	RJC	SE
2B	-1 DELETED $\nabla \phi .37 \times 90^\circ$ NEAR SIDE CALLOUT FROM 5/16-24 $\nabla .50$ BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE

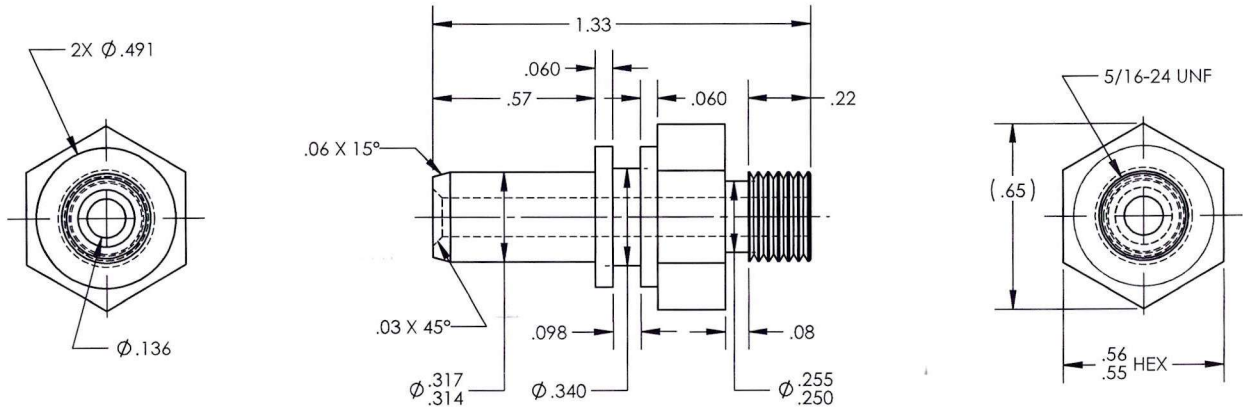
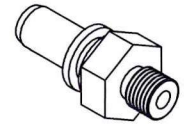


(-1)
BODY

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G-1	REV 2B
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Wed</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 6°	FINISH CLEAR ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:1	DATE 2/23/2011
SHEET 2 OF 5	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

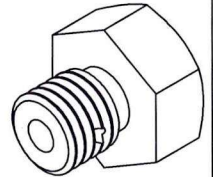
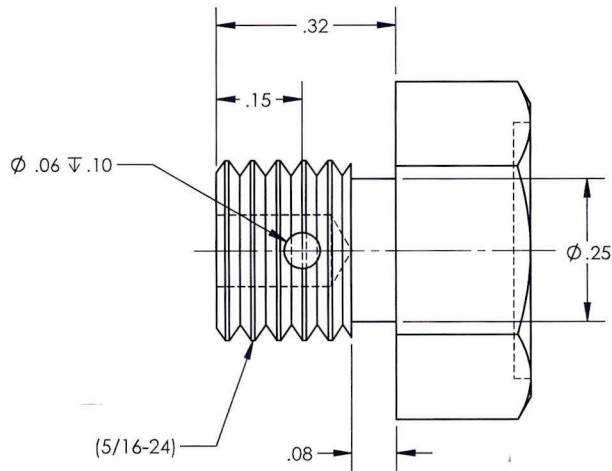
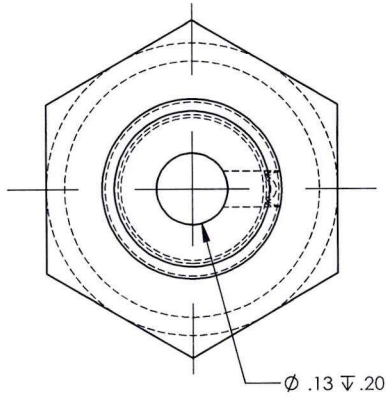


(3)
TUBE

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G-3	REV 2B
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Med</i>
.XXX ± .005 .XX ± .01 .X ± .1	REAT TREAT FINISH CLEAR ANODIZE
FRACTIONS ± 1/32 ANGLES ± 5°	SPEC MIL-A-8625, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 2:1	DATE 2/23/2011
SHEET 3 OF 5	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



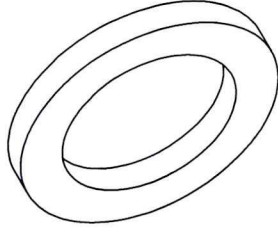
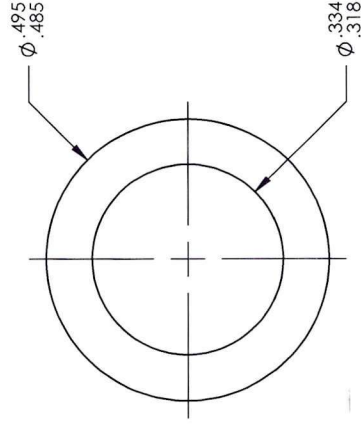
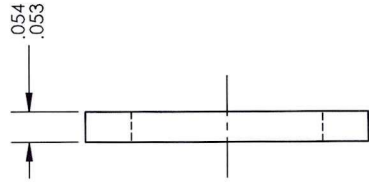
⑤

PLUG

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G-5	REV 2B
MAT'L ALUMINUM	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D. Wed</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
ANGLES ± 6°	SPEC
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
OR .015R	AGUSTA
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 4:1	DATE 2/23/2011
SHEET 4 OF 5	

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REV		REVISIONS		DATE		INITIAL		APPROVED	
REV		DESCRIPTION							



(7)

WASHER

 RED BARN MACHINE

TITLE
MAIN ROTOR DAMPER OIL ADAPTER

DWG NO. RBW1205G00231-3G-7 REV 2B

MAT'L NYLON	DRAWN BY: PERRITT	APPROVED	REV
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
.XXX ± .005			
.XX ± .01			
.X ± .01			
ANGLES ± .5°			
1. BREAK ALL SHARP EDGES .015 x .45" SPEC			
2. DIMENSIONAL LIMITS APPLY AFTER FINISH			
USED ON MODEL			
AGUSTA			
SCALE 4:1	DATE 2/23/2011	SHEET 5 OF 5	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041367

PO Date: 10/16/18

Due Date: 12/17/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185295	RBW6005G01631-3GP			Dial Indicator Swash Plate Scissors Support REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$1,150.00/pcs	\$2,300.00
Line Item Note: SIOP													
2	185392	RBW1205G00231-3GP			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,000.00/pcs	\$3,000.00
Line Item Note: SIOP													
3	185298	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
Line Item Note: SIOP													
4	185299	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
Line Item Note: SIOP													
5	185300	RBW6405G00531-3GP			Tail Rotor Damper Length Adjustment Tool REV 5	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$700.00/pcs	\$1,400.00
Line Item Note: SIOP													
6	185301	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
Line Item Note: SIOP													
7	185302	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$450.00/pcs	\$900.00
Line Item Note: SIOP													



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185303	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$400.00/pcs	\$800.00
Line Item Note: SIOP 2X DEC 18 2018 ORDER 7393 22 Jan 2019													
9	185349	RBW6205G26631-3GP			Wrench, MR Scissor Retaining Nut Removal/Install REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$280.00/pcs	\$560.00
Line Item Note: SIOP 2X DEC 18 2018													
10	185352	RBW6205G26551-3GP			Main Rotor Scissor Locknut REV B	Firmed	-	12/17/18	2 Ea	0 Ea	2 Ea	\$175.00/Ea	\$350.00
Line Item Note: SIOP 2X DEC 17 2018													
11	185353	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Line Item Note: SIOP 2X DEC 18 2018													
12	185354	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$150.00/pcs	\$150.00
Line Item Note: SIOP 1X DEC 18 2018													
13	185406	RBW6205G03451-3GP			Bolt Guide Removal & Install REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G 3X JAN 03 2019 ORDER 7393 22 Jan 2019													
14	185407	RBW6205G08451-3GP			Puller Bolt Removal REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G 3X DEC 17 2018 ORDER 7393 22 Jan 2019													
15	185423	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2019													
16	185424	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2019													
17	185429	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note: SUB ASSY FOR RBW6405G08632-3G 1X DEC 18 2018 ORDER 7393 06 Jan 2019													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G													
19	185430	RBW6205G10451-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
20	185431	RBW6205G10551-3GP			Hammer	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
21	185432	RBW6205G10351-3GP			Guide REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
22	185433	RBW6205G10251-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
23	185434	RBW6205G10151-3GP			Pusher REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
24	185435	RBW6205G10651-3GP			Stop	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
25	185461	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
26	185462	RBW6305G26631-3G-3P			Handle REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
												Grand Total:	\$23,959.98

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24530
Shipment Date: 16-Jan-2019
Ship Via: Pick up at METEC
Order Number: 3096
Order Date: 10/17/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041367 ✓
Terms: Net 60 Days

----- Quantity -----										
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job</u>	<u>Number</u>	
2	3	3 ✓	0	0	EA	DART-RBW1205G00231-3GP Main Rotor Damper Oil Adapter	2B	3096-02		DAS 38 9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number	
3 ✓	DART-RBW1205G00231- 3GP	Main Rotor Damper Oil Adapter	2B	41367 ✓	DAS 38 9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, January 16, 2019